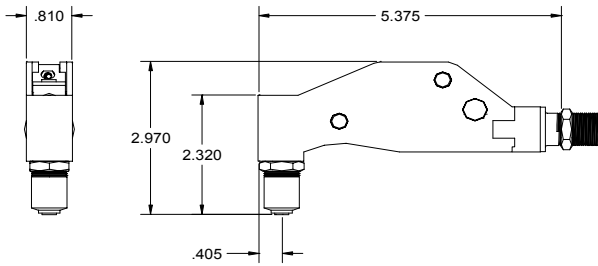


# NOSE ASSEMBLY DATA SHEET



## CAUTION!

Pintails may eject forcibly. This nose is for closed access applications. If used in open access applications, 704214 catcher bag is recommended TO PREVENT SEVERE PERSONAL INJURY, 704214 catcher bag is recommended.

| Nose Assembly | Nose Tip | Jaw Set |
|---------------|----------|---------|
| 4C-715-54RA   | 10477    | 30425   |
| 5C-715-54RA   | 15584    | 30545   |
| 6C-715-54RA   | 16698    | 30656   |

\*MOST FASTENERS REQUIRE MORE THAN ONE PULL.

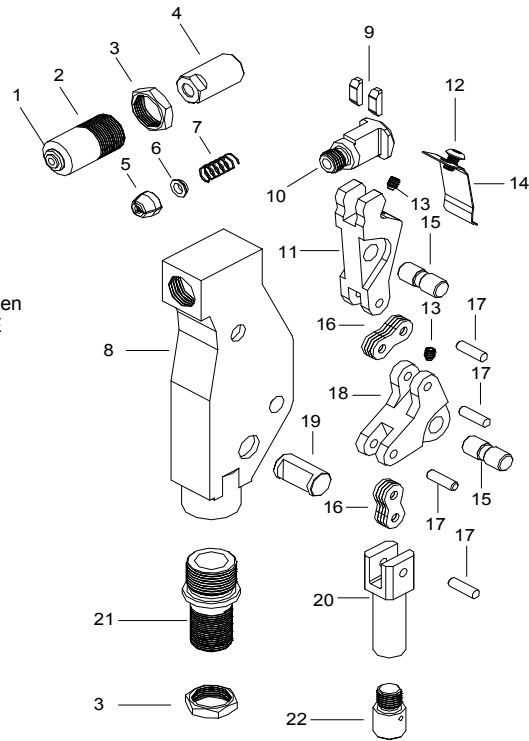
4/06

**GAGE BILT**

MADE IN U.S.A.

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Clinton Twp. MI 48038 (586) 226-1505 Fax  
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## ATTACHMENT:

Engage 1 or 2 threads of drawbolt (20) onto head piston, then insert adapter fitting (21) into end of head cylinder and turn clockwise until snug. Rotate nose assembly to desired position and tighten jam nut (3) securely.

After attaching the nose assembly to the riveter, adjust sleeve (2) by loosening jam nut (3), then insert largest diameter rivet to be installed in sleeve and rotate sleeve until jaws just grab pintail. Tighten jam nut (3) securely. By this sleeve adjustment, the nose assembly can be made to release or to hold the pintail after installation.

## DISASSEMBLY:

Loosen jam nut (3) and remove sleeve (2). Unscrew collet (4) which contains jaws (5), follower (6), spring (7) from collet bolt (10).

Remove screw (12) and guard (14). Remove 2 set screws (13) and push out 2 pivot pins (15) to permit removal of linkage. Shoe bearings (9) and collet bolt (10) will disengage from lever (11).

Remove 4 link pins (17) to disassemble lever (11), links (16), bell crank (18) and drawbolt (20).

Remove guide pin (19) from frame (8). Adapter fitting (21) is secured to frame with Loctite® and need not be removed unless damaged.

## REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (11), links (16), bell crank (18) and drawbolt (20) should be assembled as a subassembly before inserting lever (11) into shoe bearings (9) and collet bolt (10). MAKE SURE NOTCHES ON COLLET BOLT (10) ARE POINTING TOWARDS LEVER (11). This complete subassembly may then be inserted into frame (8) and retained by guide pin (19) and pivot pins (15).

| Type:                                     |      | Fasteners:                                                  | Recommended Tool:<br>GB715 |
|-------------------------------------------|------|-------------------------------------------------------------|----------------------------|
| Single Action<br>1/8", 5/32" &<br>3/16" Ø |      | MS20600, Cherry® 9000<br>Huck® PT, SP & MS<br>RV200 & RV500 |                            |
| Ref.<br>No.                               | Qty. | Description                                                 | Part Number                |
| 1                                         | 1    | Nose Tip                                                    | See Chart                  |
| 2                                         | 1    | Sleeve                                                      | 10115                      |
| 3                                         | 2    | Jam Nut                                                     | 70411                      |
| 4                                         | 1    | Collet                                                      | 20563                      |
| 5                                         | 1    | Jaw Set                                                     | See Chart                  |
| 6                                         | 1    | Follower                                                    | 40301                      |
| 7                                         | 1    | Spring                                                      | 50311                      |
| 8                                         | 1    | Frame                                                       | 75310                      |
| 9                                         | 2    | Shoe Bearing                                                | 75311                      |
| 10                                        | 1    | Collet Bolt                                                 | 70443                      |
| 11                                        | 1    | Lever                                                       | 75313                      |
| 12                                        | 1    | But. Hd Screw                                               | 402471                     |
| 13                                        | 2    | Set Screw                                                   | 75315                      |
| 14                                        | 1    | Guard                                                       | 75316                      |
| 15                                        | 2    | Pivot Pin                                                   | 75317                      |
| 16                                        | 8    | Link                                                        | 75318                      |
| 17                                        | 4    | Link Pin                                                    | 75319                      |
| 18                                        | 1    | Bell Crank                                                  | 75320                      |
| 19                                        | 1    | Guide Pin                                                   | 75321                      |
| 20                                        | 1    | Drawbolt                                                    | 75322                      |
| 21                                        | 1    | Adapter-Frame                                               | 70458                      |
| 22                                        | 1    | Collet Extension                                            | 70457                      |

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